

Work Order ID 80699

February-27-12 2:53:26 PM

80699

Page 1

Item ID: D4106-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Sill Doulber, LH
 Start Date: 27/02/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 12/03/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/02/12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4106	A

100 0.00

100

Waterjet

FLOW CNC Waterjet

304 . 050

Memo

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

ml 12, 03, 06 (6)

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Quality Control

Memo

0.00

ml 12, 03, 06 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(46)			
130 *130* Small Fab Small Fab	Memo 1- C'sink holes as per dwg 2- Use press to start forming D4106-1 as per dwg using DT9646. Then finish the shape of D4106-1 by hand.	0.00 0.00							
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo ***Use DT9646 for inspection***	0.00 0.00				(46)			

Handwritten notes: 12/03/19 (6) FF 12-03-27

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Page 3

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Sill Douber, LH

Start Date: 27/02/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>127</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12-03-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

February-27-12 2:53:31 PM

Page 1

Work Order ID: 80699

80699

Parent Item: D4106-1

D4106-1

Parent Item Name: Sill Doulber, LH

Start Date: 27/02/2012

Required Date: 12/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	284.5050	0.2109	1.332			

M304S18GA

304/316 .050 Sheet

**

W 12-03-06

Location

Loc Qty

Loc Code

MAT020

284.505

119032

17.3

119383

96

119766

25.205

120243

26

120604

120

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NOTE: Date & initial all entries

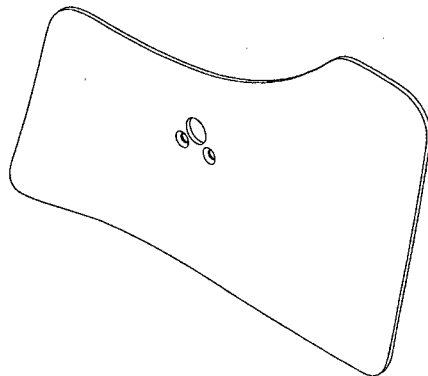
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

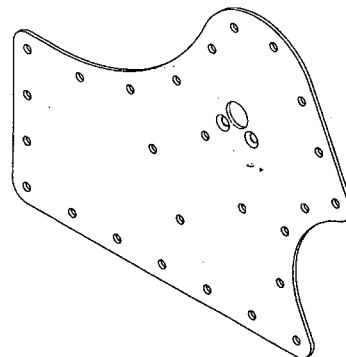
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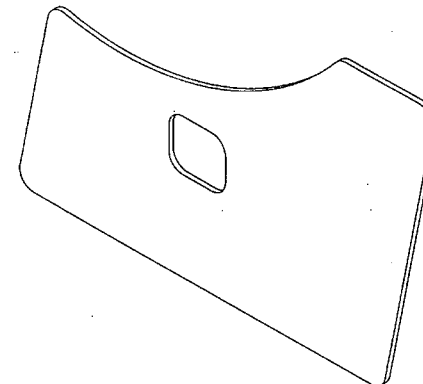
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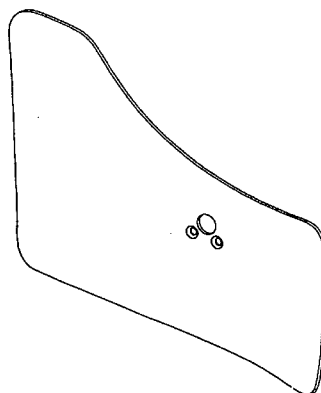
D4106-1 SILL DOUBLER, LH



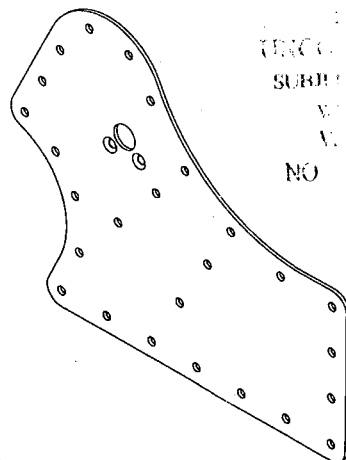
D4106-3 CREW DOOR DOUBLER, LH



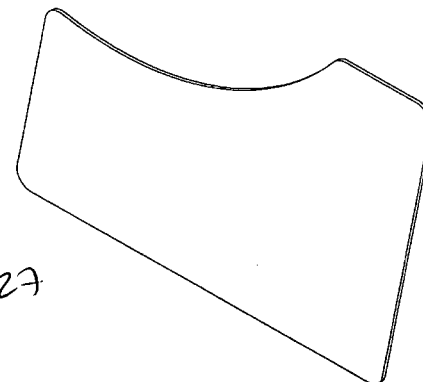
D4106-5 SPACER, SILL DOUBLER



D4106-2 SILL DOUBLER, RH



D4106-4 CREW DOOR DOUBLER, RH



D4106-7 TEMPLATE

NO 80699 MCT
12/02/27

RELEASED
2010-09-23
MM

A		NEW ISSUE		JPH	10.07.15
REV.	DESCRIPTION			BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	JPH				
CHECKED	JPH	DRAWING NO.	REV. A		
MFG. APPR.	JPH	D4106	SHEET 1 OF 5		
APPROVED	JPH	TITLE	SCALE		
DE APPR.	JPH	DOUBLERS	NTS		
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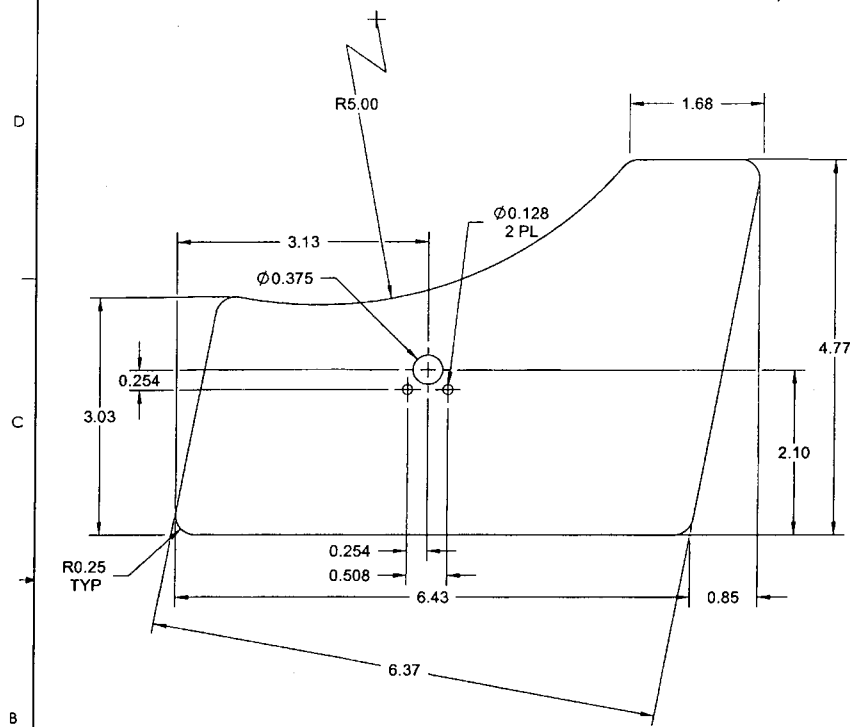
W/O:		WORK ORDER CHANGES					
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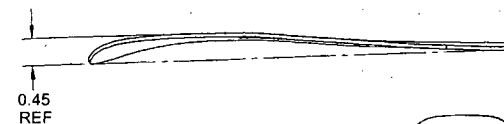
NOTE: Date & initial all entries



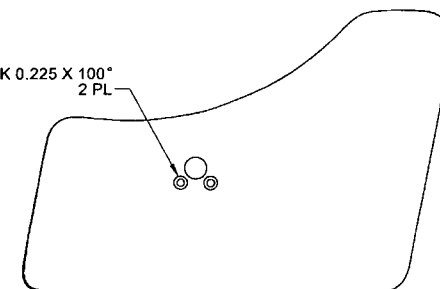
D4106-1F FLAT PATTERN, SILL DOUBLER

NOTES:

- 1) MATERIAL -1F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA OR M303S18GA
-1 & -2: MAKE FROM D4106-1F.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION -1 & -2: IDENT P/N D4106-X AND B/N PER QSI 044 6.1
- 7) WEIGHT -1 & -2: 0.34 lbs
- 8) FORM & INSPECT PER TEMPLATE DT9646 FOR D4106-1
DT9647 FOR D4106-2



CSK 0.225 X 100°
2 PL

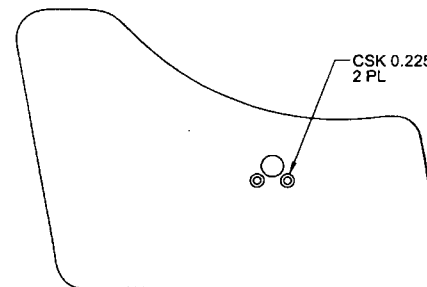


D4106-1 SILL DOUBLER, LH (MAKE FROM D4106-1F)

20699



CSK 0.225 X 100°
2 PL



D4106-2 SILL DOUBLER, RH (MAKE FROM D4106-1F)

RELEASE
2010-09-30

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4106	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		DOUBLERS	NTS
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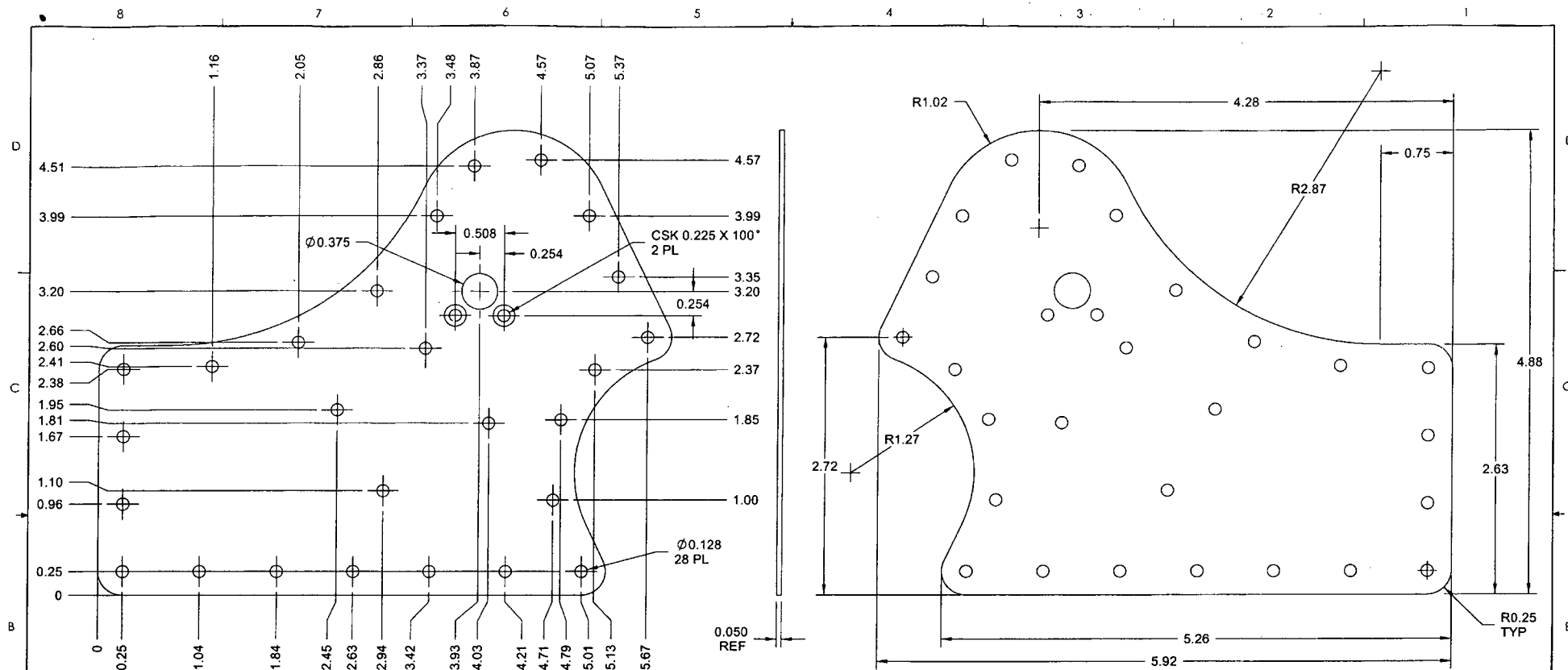
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NOTE: Date & initial all entries



D4106-3 CREW DOOR DOUBLER, LH

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA OR M303S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-3 AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.27 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4106	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 5	
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DATE	10.07.15		

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2010-09-23
NP

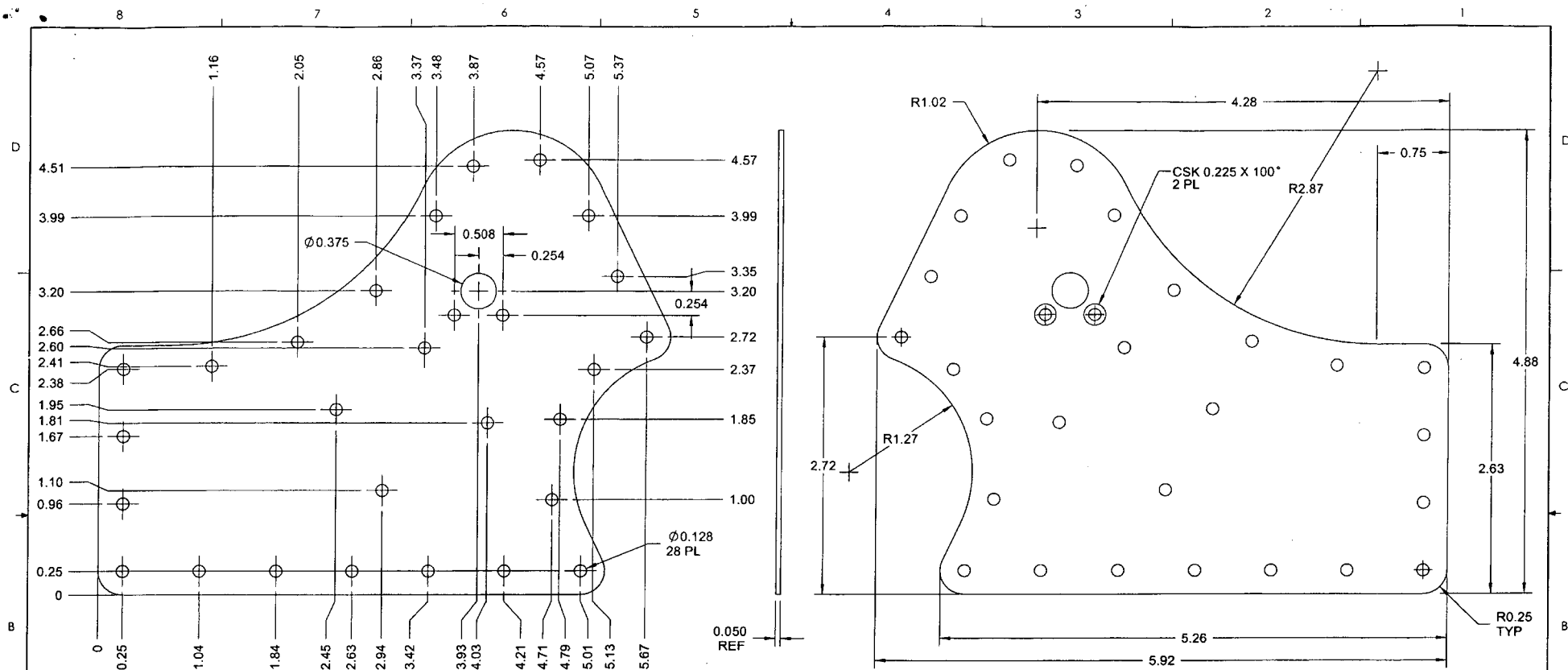
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NOTE: Date & initial all entries



D4106-4 CREW DOOR DOUBLER, RH

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA OR M303S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-4 AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.27 lbs

DESIGN	JPH	DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4106	SHEET 4 OF 5
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2010-09-23

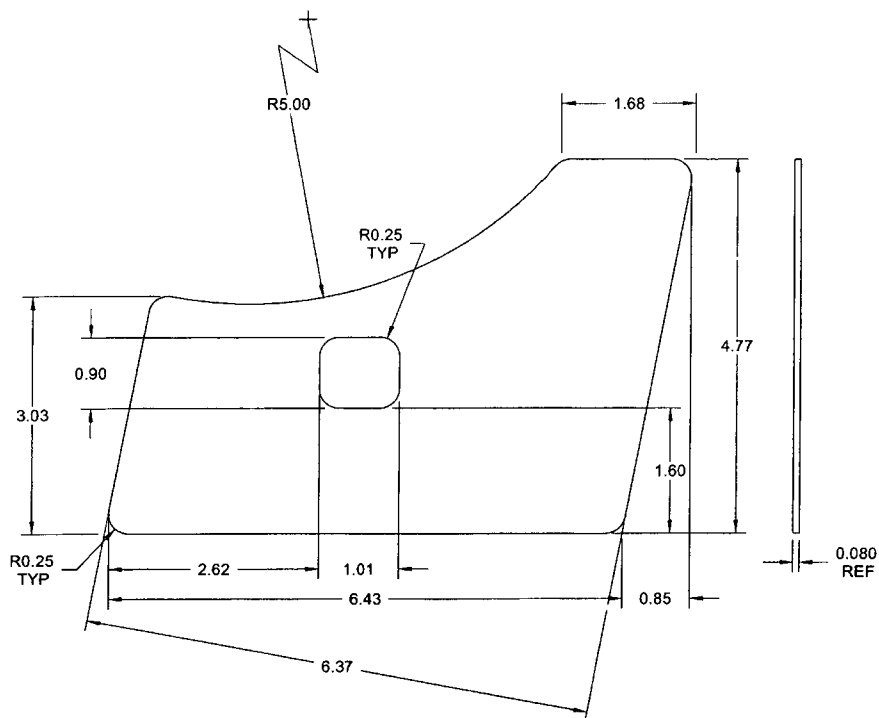
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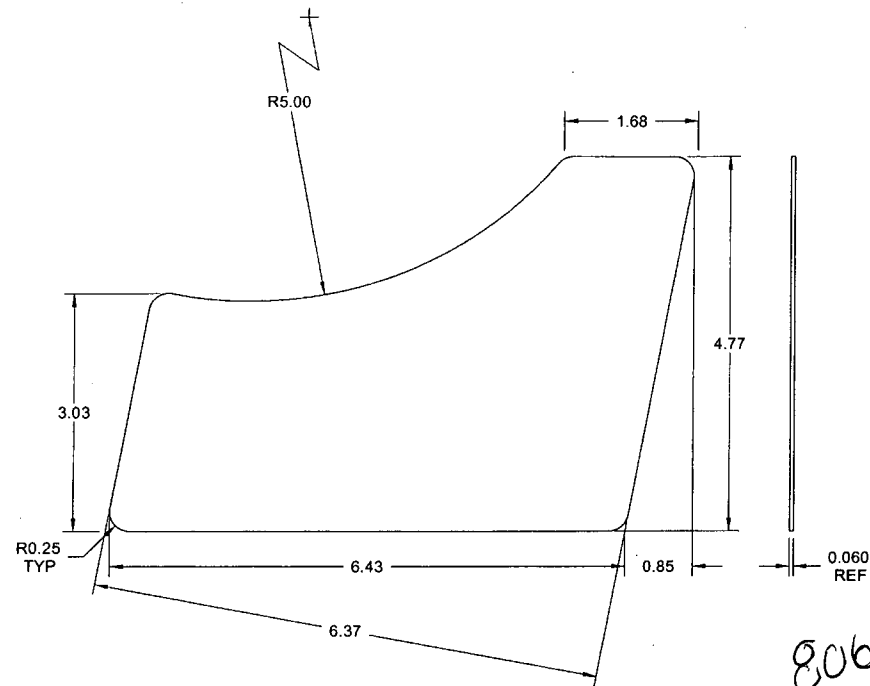
NOTE: Date & initial all entries



D4106-5 SPACER, SILL DOUBLER

NOTES:

- 1) MATERIAL -5: KYDEX 6185 SHEET, 0.080 THK
REF DART MKYD6185S.080-P3-52068 OR MKYD6185S.080-P3-62015
- 7: LEXAN 9034 SHEET, 0.060 THK
REF DART MLEXS 060-9034-08
OR POLYCAST II CLEAR ACRYLIC, .060 THICK.
REF DART M-ACRYLIC-S.060
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-X PER QSI 044 6.1
- 7) WEIGHT -5: 0.08 lbs
-7: N/A



D4106-7 TEMPLATE

RELEASED
2010-09-23
NW

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DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4106	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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